| Work Orde October 28, 200 | | | | | | | | | | | | Page 1 |
|---|-------------------------------|--|--|--|----------------|--------------|--------------|--------------|--------------|---------------|---------------------|------------------------------------|
| Item ID: Revision ID: Item Name: Start Date: | D3173-041 B Beam Assemb | Start Qty: 2.00 | | Accept | Cust Item I | | | | Setup | Start Stop | | 11. 11. 11. 11. 11. 11. 11. 11. |
| Required Date: Reference: | 10/30/09 | Req'd Qty: 2.00 | | | Customer: | | _ | | D | Start | 1 (26f)(8) 1 | |
| Approvals: | Process Pla | an: | Date: | Tooling: SPC (Y/N): | | ite: ite: | | | Run | Start Stop | | |
| Sequence ID/ Work Center II | | Operation Description | | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | | vision Nbr | | | | | | | | | | |
| D3173 | Rev | B | | | | | | | | | | |
| 100 Bandsaw | | BAND SAW | | 0.00 | | | | | | | | |
| Jeaspa Bandsaw | | | 56" long ☐Machine holes entify as D3173-1 | | Dwg | | * 1 | | | | | |
| 110 HAAS 1 HAAS CNC vertica | I machine #1 | HAAS CNC VERTICA Memo Machine h | AL MACHINING #1 oles as per Folio FA295 and | 0.00 0.00 d Dwg D3173Identify as | D3173-1 | /// | | | | | | |
| 120 | • | OC2- Inspect parts off | machine FAI/FAIB | 0.00 | | | | | | | | |

Quality Control

Jul 13173-1 from stock B 20356 SB 209/10/29

Page 2

October 28, 2009 7:09:47 AM

Work Order ID 53230

| • |
|---|
| |

D3173-041

Accept

Setup Start

Stop

Start



В **Revision ID:**

Item Name: Beam Assembly

Start Date:

10/28/09

Start Qty: 2.00

Required Date: 10/30/09 Req'd Qty: 2.00

QC:



Cust Item ID: Customer:

Reference:

| Approvals: | Process Plan: | Date |
|------------|---------------|------|
| | | |

Date:_____

Tooling: SPC (Y/N):

0.00

0.00

0.00

Date:

Date:

Stop

Run



Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 0.00

Number

Draw

Draw Rev.

Plan Accept Code Qty

Reject Qty

140

Small Fab

Small Fab

Small Fab

Memo

1-Drill Ø0.316" holes as per Dwg D2173 □2-C'sink holes as per Dwg

D3173 □3-deburr

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

QC

Quality Control

Reject Insp. Number Stamp

Work Order ID 53230



Page 3

October 28, 2009 7:09:55 AM

Item ID:

D3173-041

В

Revision ID:

Item Name: Beam Assembly

Start Date:

10/28/09

Start Qty: 2.00 Required Date: 10/30/09

Req'd Qty: 2.00



Accept

Setup Start



Reference:

Approvals:

Process Plan:

Date: Date: **Tooling:**

SPC (Y/N):

Date:

Cust Item ID:

Customer:

Draw

Number

Date:

Draw

Rev.

Plan

Code

Accept

Qty

Start Run

Reject

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ Work Center ID

160

HandFinish

Hand Finishing

170

Quality Control

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

QC5- Inspect part completeness to step on W/O

Memo

Set Up/ **Run Hours**

0.00

0.00

0.00

BL 09-11-2

180

Powdercoat **Powder Coating** White Gloss(Ref: 4.3.5.1) per QSJ005 4.3-Alum

M 1/2/48

Memo

TIME:

Ensure Nut Plate thread is covered.

Plate thread is covered.

_OVEN TEMPERATURE:
__OFINISH

0.00

0.00

D .

Work Order ID 53230

В

October 28, 2009 7:09:55 AM



Page 4

Item ID:

D3173-041

OC:

Accept

Accept

Qty

Setup Start

Stop



Revision ID:

Item Name: Beam Assembly

Start Date: Required Date: 10/30/09

10/28/09

Start Otv: 2.00

Rea'd Oty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run Start



Sequence ID/ Work Center ID

190

Operation Description

OC3- Inspect Part Finish

Memo

Set Up/ Run Hours

Draw Number Draw Rev.

Plan Code Reject Oty

Reject Number

Insp. Stamp

Quality Control

0.00

Small Fab

200

Small Fab

Small Fab

Memo

0.00

Assemble per Dwg D3173.

□Install Mounting Lug as per Dwg D3173.

D3175-

041 is included in K10017 BOM.

QC5- Inspect part completeness to step on W/O

210

Quality Control

Memo

Work Order ID 53230

October 28, 2009 7:09:56 AM



Page 5

Item ID:

D3173-041

Revision ID: В

Item Name:

Beam Assembly

Start Date:

10/28/09

Accept

Setup Start

Stop



Required Date: 10/30/09

Req'd Qty: 2.00

Start Qty: 2.00

Cust Item 1D: Customer:

Reference:

| A | nr | | 0.1 | al | |
|---|----|---|-----|----|----|
| A | DI | r | IJν | 21 | N: |

QC:

Process Plan:

Date: Date: ____ **Tooling:**

SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/

Work Center ID

220

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

0.00 Memo Packaging

230

QC Quality Control QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

October 28, 2009 7:09:44 AM

Work Order ID: 53230

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly



Start Date: 10/28/09

Required Date: 10/30/09

| Comments: | | | | | | | | S | tart Qty: 2.00 | | Required Qty: | 2.00 |
|---------------------------------|------------------------|---------------|-------------|---------------------|---------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
| AN3-5A | | Purchased | No | | | 200 | Each | 2,247.000 | 16.0000 | <i>P</i> \$09 | /1/03 | |
| | | | | Wareho | <u>use</u> | Loc | <u>Oty</u> | Loc Code | | / / | | |
| | | | | Loca | ation_ | | | | | | | |
| | | | | Main Wa | arehouse | | | | | | | |
| | | | | ST | | | 2247 | | _ | | | |
| | | , | | | 100188 | | 188 | | _ | • • • | | |
| AN5-23A | | Purchased | No | | 105057 | 200 | 2059 Each | 23.0000 | 4.0000 | 4509 | 100/03 | |
| Bott | | | | Wareho Loc | <u>use</u> ation | Loc | <u>: Oty</u> | Loc Code | | // / | / / | |
| | | | | Main W | arehouse | | | | | | | |
| | | | | ST | | | 23 | | _ | | - | |
| | | | | | 19278 | | 23 | | _ | 4 | _ | |

October 28, 2009 7:09:45 AM

Work Order ID: 53230

Parent Item:

D3173-041RevB

Parent Item Name:

Beam Assembly



Last

Start Date: 10/28/09

Required Date: 10/30/09

Start Qty: 2.00

Required Qty: 2.00

| Component Item | ID/ |
|-----------------------|-----|
| Item Name | |

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Route Location

Unit of Seq ID Measure

Qty on Hand

Remaining Qty To Pick Issued

Qty

Date Status Issued

Page 2

AN960JD10

Comments:

Purchased

No

200

Each

1,736.000 16.0000

| Washer | | |
|--------|--|--|

| Warehouse | Loc Qty | Loc Code | |
|-----------------|---------|----------|----|
| Location | | | • |
| Main Warehouse | | | |
| ST | 1736 | | |
| 105442 | 95 | | |
| 109059 | 2 | | |
| 109840 | 23 | | |
| 110985 | 202 | | |
| 111279 | 5 | | |
| 111668 | 64 | | |
| 112314 | 968 | | |
| 112369 | 377 | | 16 |

October 28, 2009 7:09:45 AM

Work Order ID: 53230

Parent Item:

D3173-041RevB

Parent Item Name: Beam Assembly



Start Date: 10/28/09

Required Date: 10/30/09

Page 3

Required Oty: 2.00

| Comments: | | | | | | | | S | tart Qty: 2.00 | | Required Qty: 2. | .00 |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|------------------|----------|
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
| AN960JD516 | | Purchased | No | | | 200 | Each | 1,565.000 | 8.0000 | Spo | 20/11/20 | 3 |
| | | | | Wareho | use | Loc | <u>Oty</u> | Loc Code | | | ′ / | |

| Warehouse | Loc Qty | Loc Code | | |
|-----------------|---------|----------|--------|-------------|
| Location | | | | |
| Main Warehouse | | | | |
| ST | 1565 | | | |
| 100564 | 2 | | | |
| 106167 | 6 | | | |
| 107534 | 34 | | | |
| 107959 | 43 | | | |
| 108246 | 46 | | | |
| 108672 | 2 | | | |
| 109059 | 49 | | | |
| 109752 | 22 | | | |
| 110363 | 46 | | | |
| 110523 | 57 | | | |
| 111279 | 39 | | | |
| 112082 | 68 | | | |
| 112314 | 500 | | | |
| 112794 | 151 | | | <u> </u> |
| 112828 | 500 | | | |
| | Each | 2.0000 | 2.0000 | Q0 1/2 |

D3173-1RevB

Manufactured

Beam

| <u>Warehouse</u> | Loe Qty | Loc Code | |
|------------------|---------|----------|--|
| Location | | | |
| Main Warehouse | | | |
| ST | 2 | | |

20356

October 28, 2009 7:09:45 AM

Work Order ID: 53230

Parent Item:

D3173-041RevB

Parent Item Name: Beam Assembly





Start Date: 10/28/09

Required Date: 10/30/09

Page 4

| Comments: | | | | | | | | 5 | Start Qty: 2.00 | | Required Qty: 2.0 | 00 |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|-------------------|------------------|
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
| D3175-041RevA | | Manufactured | No | | | 200 | Each | 6.0000 | 4.0000 | Eso: | 9/11/03 | |
| | | | | Wareho | <u>use</u> | Loc • | <u>Qty</u> | Loc Code | | , | | |
| | | | | Loca | <u>ition</u> | | | | | | | |
| | | | | Main Wa | ırehouse | | | | | | | |
| | | | | ST | | | 6 | | _ | | | |
| | | | | | 25025 | | 1 | | . – | | | |
| D3178-041RevA | | NA Conton 1 | No | | 41678 | 170 | 5 Each | 18.0000 | 4.0000 | _4 | | |
| Nut Plate | | Manufactured | NO | | | 170 | Eacii | 18.0000 | 4.0000 | Esc | 29/11/03 | ·- · |
| | | | | <u>Wareho</u> | use | Loc | <u>Oty</u> | Loc Code | | | | |
| | | | | Loca | ation_ | | | | and the second | | | |
| | | | | Main Wa | arehouse | | | | • | | | |
| | | | | ST | | | 18 | | _ | | | |
| | | | | | 24895 | • | 10 | | | 4 | | |
| N. (000.401 A.D. (11).4 | | | | | 25298 | | 8 | 47.0000 | | | / | |
| MS20601-AD4W4 | | Purchased | No | | | 200 | Each | 47.0000 | 16.0000 | Esc | 9/11/03 | |
| Kivet | | | | Wareho | use | Loc | Oty | Loc Code | -1. | | | |
| | | | | | ation | ···· | | | | / | | |
| | | | | Main W | arehouse | | | | | | | |
| | | | | ST | | | 47 | | | | | |
| | | | | | 19278 | | 47 | | | 16 | | |

Page 5

October 28, 2009 7:09:46 AM

Work Order ID: 53230

D3173-041RevB

Parent Item Name:

Parent Item:

Comments:

Beam Assembly



Last

Start Date: 10/28/09

Required Date: 10/30/09

Start Qty: 2.00

Required Qty: 2.00

| · •——— | | |
|-----------|------|-----|
| Component | Item | ID/ |
| Item Name | | |

Replacement Mfg/ Item ID

Purch

Bin **Primary** Location Item

Location

Route Seq ID Unit of Measure

Qty on Hand

Remaining Qty Qty To Pick Issued Date Issued

Status

MS21042L5

Purchased

No

100

Each

1,065.000 4.0000

| Nut | | |
|-----|--|--|

| Warehouse Location | Loc Oty | Loc Code | |
|--------------------|---------|----------|---|
| Main Warehouse | | | |
| ST | 1065 | - | |
| 110382 | 10 | | |
| 111127 | 4 | | |
| 111636 | 51 | | 4 |
| 112314 | 1000 | | |
| | | | |





| | DESIG | P | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|---|-------|-------|----------|--|--------|
| | CHECH | ED, | APPROVED | DRAWING NO. | REV. B |
| 7 | | # | -# | D3173 SHEET | 1 OF 3 |
| 1 | DATE | ····· | | TITLE | SCALE |
| | 03.0 | 1.07 | | BEAM ASSEMBLY | NTS |
| | Α | | 02.12.03 | NEW ISSUE | |
| | В | | 03.01.07 | REMOVE PIP PINS | |

NV 53230

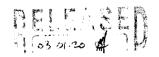
PARTS LIST

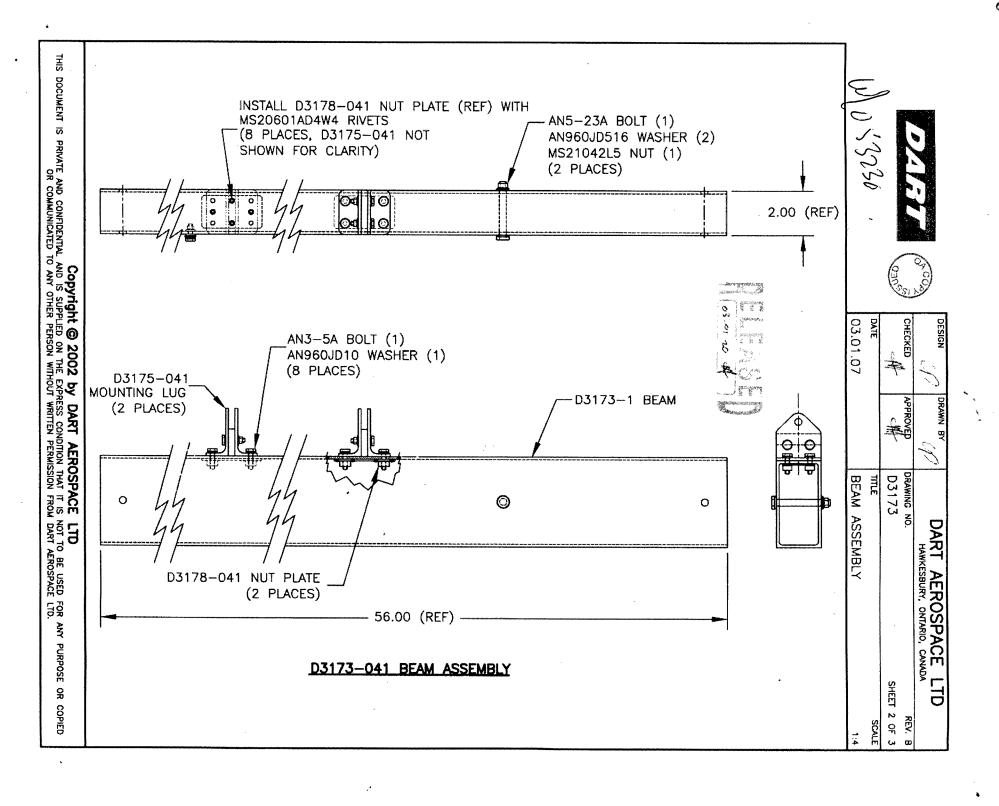
| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|---------------|
| Х | D3173-041 | BEAM ASSEMBLY |
| 1 | D3173-1 | BEAM |
| 2 | D3175-041 | MOUNTING LUG |
| 2 | D3178-041 | NUT PLATE |
| 8 | AN960JD10 | WASHER |
| 4 | AN960JD516 | WASHER |
| 2 | MS21042L5 | NUT |
| 8 | MS20601AD4W4 | RIVET |
| 8 | AN3-5A | BOLT |
| 2 | AN5-23A | BOLT |

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8) (REF DART SPEC. M6061T6TR4.0x2.0W125
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

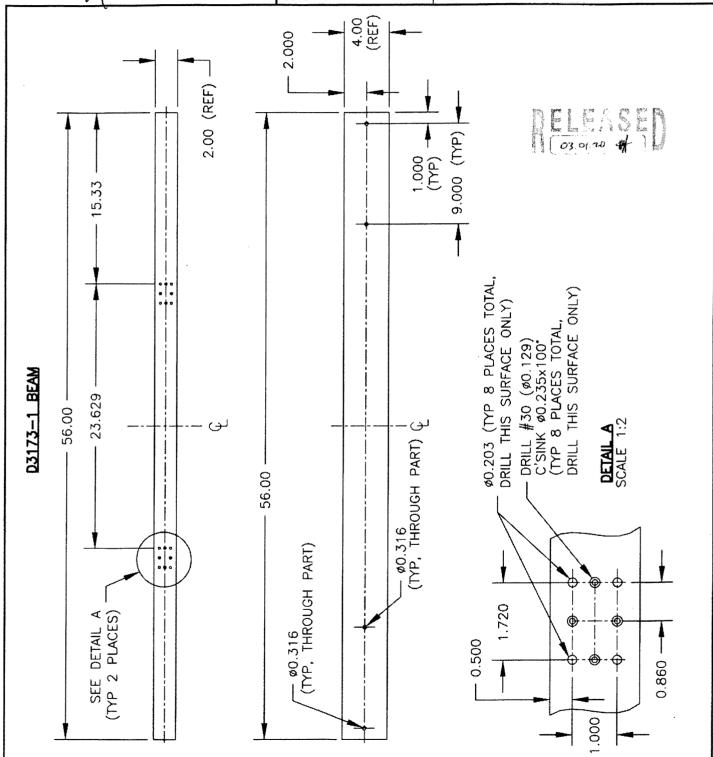








| DESIGN | DRAWN BY | | AEROSPACE LTD SBURY, ONTARIO, CANADA | |
|-----------|----------|---------------|---|--|
| CHECKED , | APPROVED | DRAWING NO. | REV. B | |
| # | # | D3173 | SHEET 3 OF 3 | |
| DATE | <u> </u> | TITLE | SCALE | |
| 03.01.07 | | BEAM ASSEMBLY | 1:8 | |



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